

Date: Monday, 6/12/2006 3:36:37 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD MOUNTING LUG
Job Number : 27502	
Estimate Number : 10454	
P.O. Number : N/A	Part Number : D26161
This Issue : 6/12/2006 S.O. No. : N/A	Drawing Number : D2616 REV D3
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D3
Previous Run : N/A	Material : N/A
Written By : <u>SA 06.06.13</u>	Due Date : 7/30/2006 Qty: 100 Um: Each
Checked & Approved By : <u>SA 06.06.13</u>	
Comment : Est Rev: 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.1749 f(s)/Unit Total: 17.4930 f(s)
 Material: 6061-T6 QQ-A-200/8 2" X 1" Bar
 Batch 1101000

ml 06/06/24 100

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.000" long +0.030" -0.000"

ml 06/06/24 100

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-1 & DWG D2616

2-Tumble & Deburr

ml 06/06/26 100

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/06/26 100

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

sn 06/06/29 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:36:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 27502

Part Number: D26161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-06-29 (100)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

DL 06/07/05 (100)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 07 08 (100)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2611 Bearing *68x27525*
32 B25009

SB 06/07/19 100

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

SB 06/07/19 100
M.F. 06-07-07 (100)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-19 (99)
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-19	10.0	1 part scrapped. bearing was press fit. Head cracked & damaged the bearing & the part.	<i>AB</i> QSR	des lvy.	9A0 06-07-18	<i>[Signature]</i> 06-07-19	<i>AB</i> QSR	<i>[Signature]</i> 06-07-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:36:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 27502

Part Number: D26161

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5193

Rec'd 6/12/11

(99)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 109/11

(98)

Job Completion



Lu 2609.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

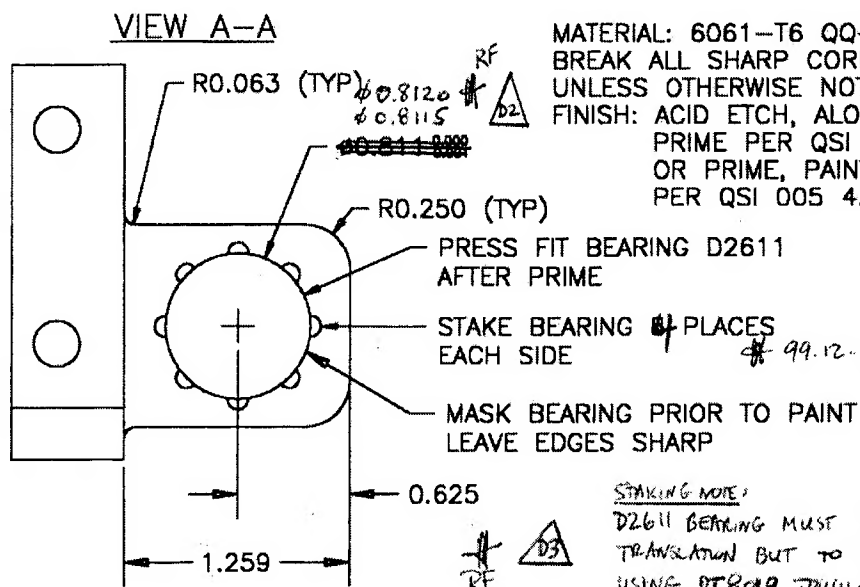
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN BW		DRAWN BY KE		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]		APPROVED BW		DRAWING NO. D2616	
DATE 97.07.31		TITLE FWD MOUNT LUG		REV. D SHEET 1 OF 1	
A	96.10.20	ORIGINAL ISSUE			
B	97.05.06	RE-DESIGN			
C	97.06.04	REMOVE D2616-3			
D	97.07.31	D2611 WAS CBA-6-B2			

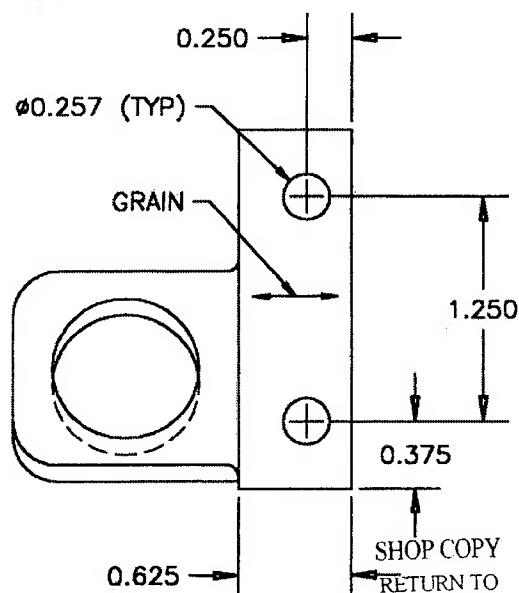
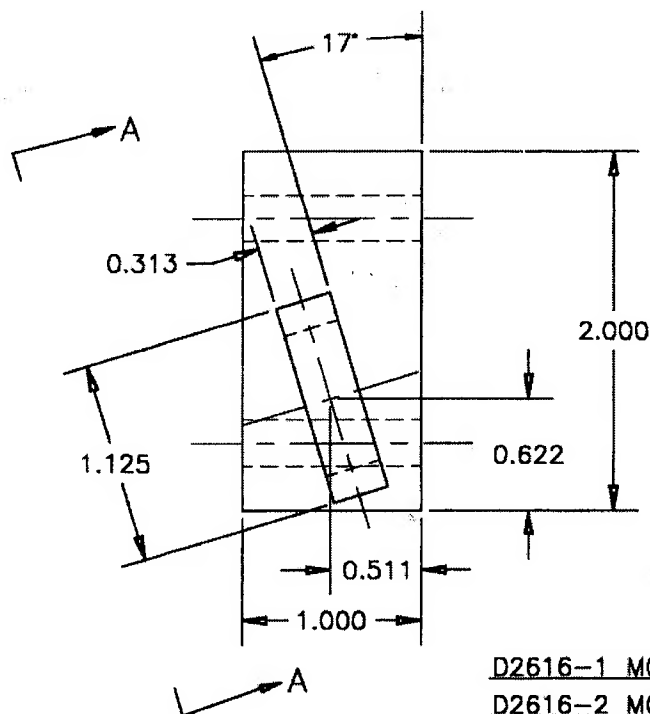


MATERIAL: 6061-T6 QQ-A-200/8
BREAK ALL SHARP CORNERS 0.010 TO 0.020
UNLESS OTHERWISE NOTED
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME PER QSI 005 4.2
OR PRIME, PAINT PER CUSTOMER SPEC
PER QSI 005 4.2

RELEASE
970731 BW

STAKING NOTE:

D2611 BERRING MUST BE STAKED TO PREVENT TRANSLATION BUT TO STILL ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD		Work Order: 27502
Description: FWD MOUNT LUG		Part Number: D2616-1
Inspection Dwg: D2616, Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

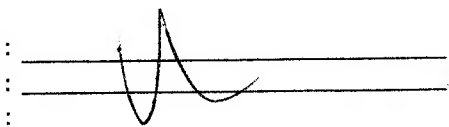
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	± 0.010	0.623	✓			
0.375	± 0.010	0.373	✓			
1.250	± 0.005	1.251	✓			
0.250	± 0.010	0.249	✓			
Ø 0.257	± 0.005 ± 0.001	Ø 0.258	✓			
2.000	± 0.010	1.997	✓			
1.000	± 0.010	1.005	✓			
1.125	± 0.010	1.127	✓			
0.313	± 0.010	0.314	✓			
17°	$\pm 1/2^\circ$	17°	✓			
1.259	± 0.010	1.260	✓			
0.625	± 0.010	0.622	✓			
R 0.063	± 0.010	R 0.063	✓			
Ø 0.8115	± 0.0005 -0.0000	Ø 0.8117	✓			

Measured by: JML	Audited by: JL	Prototype Approval:
Date: 06/06/25	Date: 06/06/25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Friday, 28/09/2007 10:26:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2616-1/-2/-3
Job Number	: 34905		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D26161
This Issue	: 28/09/2007 S.O. No. :	Drawing Number	: NCR 230-REWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 05/10/2007
Checked & Approved By	:	Qty:	146 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK:

D2616-1 { B 14634 / B15818 (2 B# on bag) / 2654 } already punch 4 Hols.
 { B27502 } already punched 8 Hols (2679)

D2616-2 B —

D2616-3 B —

ml 08/03/10 X133

2.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

REWORK PER NCR 230

ml 08/03/10

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RESTOCK USING SAME B/N

ST468

AS 08/03/11 (X133)